

Work Order ID 123543

Thursday, August 07, 2014 11:18:19 AM

123543

Page 1

Item ID: 647.3911

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 212 Upper Deflector

Start Date: 7/31/14

Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/07/14

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 14-08-11

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.3900	C (ECN)

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blank at 34.125"

*** ONE BLANK MAKES TWO PARTS***

0.00

0.00

2

Ø

M4

14/09/04

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB299

DWG REV: C

FOLIO REV: BA

2- deburr and break all sharp edges

0.00

0.00

B.A 14/09/07

2/

Ø

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Thursday, August 07, 2014 11:18:19 AM

123543

Page 2

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 7/31/14 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 8/07/14 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

120

0.00

B. a 14/09/07

4

✓

**DAS
08
9-89**

Memo

Quality Control

0.00

130

0.00

Memo

Quality Control

**DAS
20
9-89.**

L

Ø

14-09-08

0.00

140

0.00

Memo

Outsource process - Anodize

Issue P/O to ATG : 25743

1- Black Anodize as per Dwg 647.3900

2- PRIME AS PER DWG, SEE NOTE #9

Certification of Conformity is required

CL 14/09/11 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Doc/Data									
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Work Order ID 123543

123543

Page 3

Thursday, August 07, 2014 11:18:19 AM

Item ID: 647.3911 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 212 Upper Deflector
 Start Date: 7/31/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/07/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	Receive & Inspect for Damage & Mat'l Certs	0.00							
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150

Packaging

Memo

0.00

Packaging

2/4/13 *(4)*

155	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

155

QC

Memo

0.00

Quality Control

4

DAS
38
9-89

14-9-25

180	Identify as per dwg & Stock Location: <i>CDK022</i>	0.00							
-----	---	------	--	--	--	--	--	--	--

180

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

4X

SEP 25 2014

68-6
28
SVD

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 123543

Thursday, August 07, 2014 11:18:19 AM

123543

Page 4

Item ID: 647.3911 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 212 Upper Deflector
Start Date: 7/31/14 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/07/14 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 14-09-26

MF 14-9-26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

Thursday, August 07, 2014 11:18:19 AM

Page 1

Work Order ID: 123543

123543

Parent Item: 647.3911

647 3911

Parent Item Name: 212 Upper Deflector

Start Date: 7/31/14

Required Date: 8/07/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. A NEW ISSUE JFS 14/05/21 VERIFIED BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B0.375X6.000		Purchased	No			100	f	22.5209	1.422	5.987368			

M7075T6B0 375X6 000

**

7075-T6 BAR 0.375" X 6.000"

Location

Loc Qty

Loc Code

MAT049

22.5209

M128038

4.2167

M129891

18.3042

1130175

5.9

11/14/08/04

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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FAULT CATEGORY

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<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		
<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

DART AEROSPACE LTD	Work Order: 123543
Description: 212 UPPER DEFLECTOR	Part Number: 647.3911
Inspection Dwg: 647.3900 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125x45°	+/- .005 / * - .5°	0.125x45°	✓		Vern	GA-13
Ø 0.177	+ .005 / - .001	Ø 0.178	✓		"	"
4.220	+/- .002	4.220	✓		"	"
2.110	+/- .002	2.110	✓		"	"
15.896	+/- .005	15.897	✓		H-G	31006
0.700	+/- .005	0.700	✓		Vern	GA-13
0.340	+0.000 / - .002	0.3385	✓		Mic	GA-03
Ø 0.189	+ .005 / - .001	Ø 0.190	✓		Vern	GA-13
40.2°	+/- .5°	40.2°	✓		Angle M.	CNC-12
35.8°	+/- .5°	35.8°	✓		"	"
0.312	+/- .005	0.314	✓		H-G	31006
6.446	+/- .005	6.447	✓		"	"
15.046	+/- .005	15.044	✓		"	"

Measured by: BA	DAS 08 9-89	Audited by: 20	DAS 9-89	Preliminary Approval:
Date: 14/09/07		Date: 14-09-08		Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04556

SHEET 1 OF 1

DWG NO. 647.3900

REV: C

PREPARED BY D. MEJIA

DATE: 06/10/2014

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: DEFLECTORS

APPROVED BY: ENGR *[Signature]*

MFG *[Signature]*

QC *[Signature]*

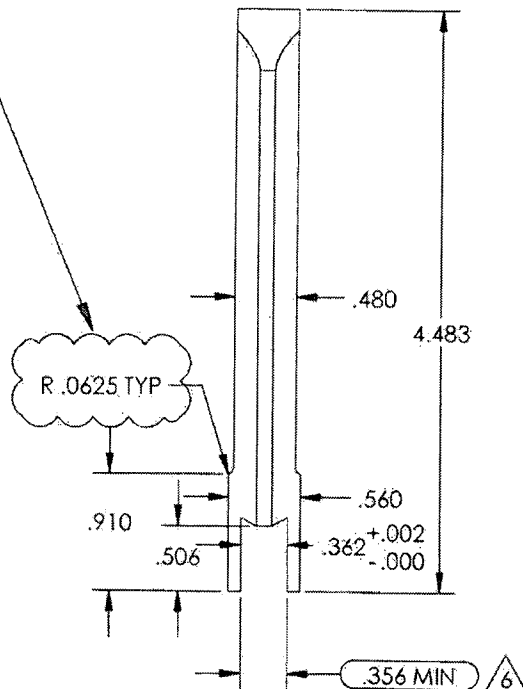
EFF. NEXT ORDER

TRANSACTION CODES (TC):
A-ADD
R-REVISE
C-CREATE
D-DELETE

REASON: DIMENSION CHANGE

ECR: D-14-04

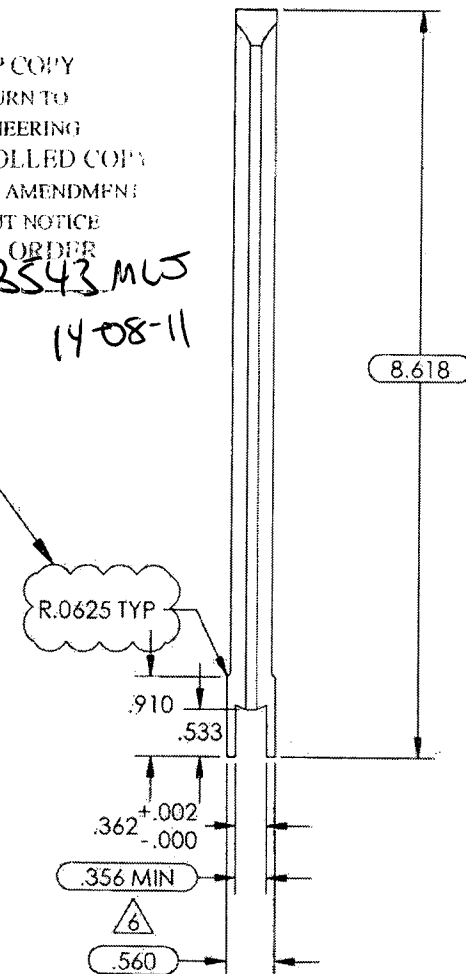
IS



SHEET 5, ZONE C6 IS:

IS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 123543 MJS
1408-11



SHEET 6, ZONE C6 IS:

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

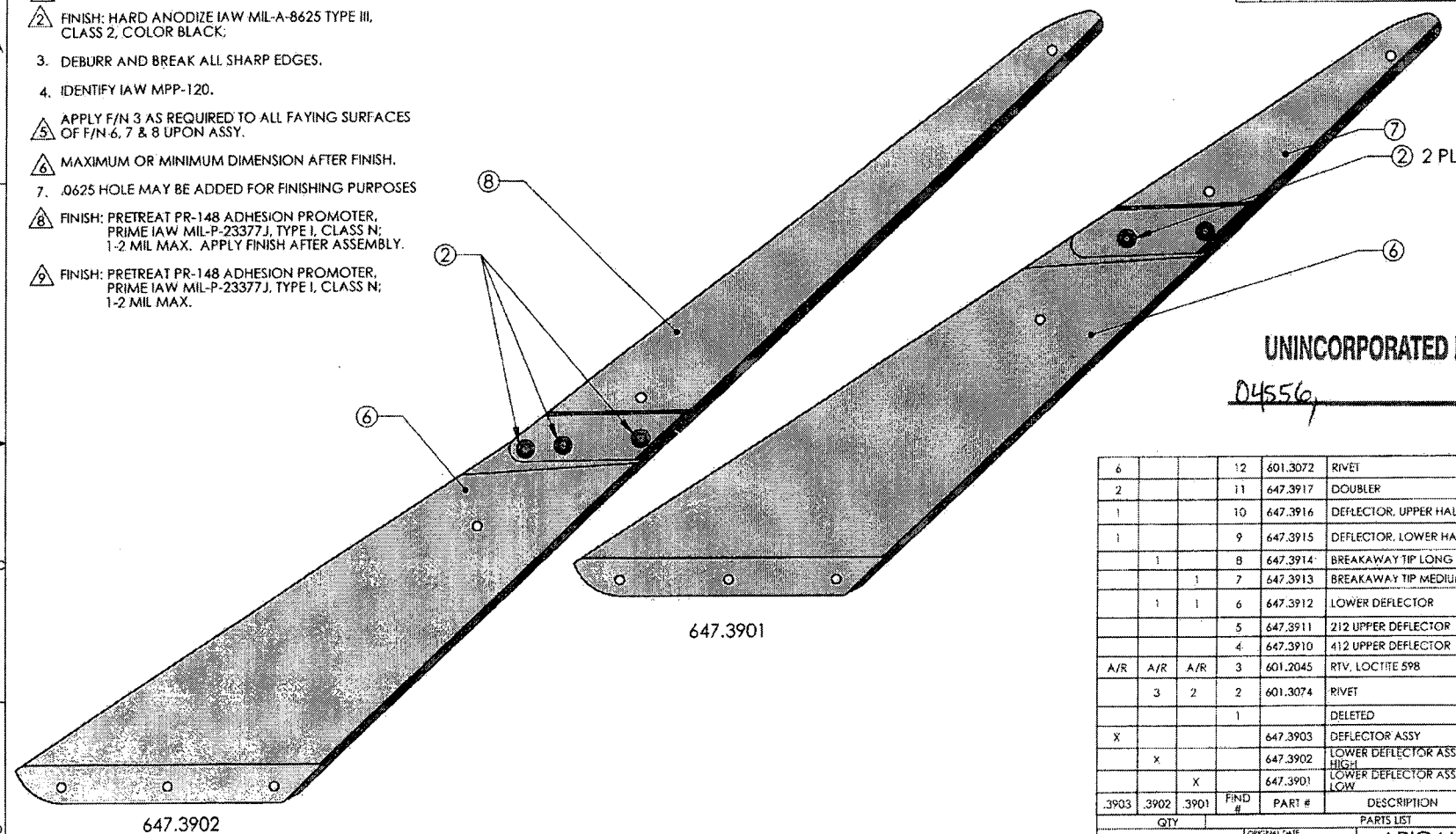
☐ YES ☒ NO

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NOTES:

1. MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12.
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
5. APPLY F/N 3 AS REQUIRED TO ALL FAYING SURFACES OF F/N-6, 7 & 8 UPON ASSY.
6. MAXIMUM OR MINIMUM DIMENSION AFTER FINISH.
7. .0625 HOLE MAY BE ADDED FOR FINISHING PURPOSES.
8. FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377 J, TYPE I, CLASS N; 1-2 MIL MAX. APPLY FINISH AFTER ASSEMBLY.
9. FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377 J, TYPE I, CLASS N; 1-2 MIL MAX.

REV.	DESCRIPTION	DATE	APPROVED
1	LAST PRODUCTION RELEASE: PR1		N/C
2	INITIAL RELEASE	09/10/09	P. BRAVO
3	INCORPORATED ECN 32944, 03539 & 03575	07/24/12	P. BRAVO
4	INCORPORATED ECN 34055	06/02/13	P. BRAVO
5	INCORPORATED ECN 34938, 34955 & 04230	11/18/13	P. BRAVO



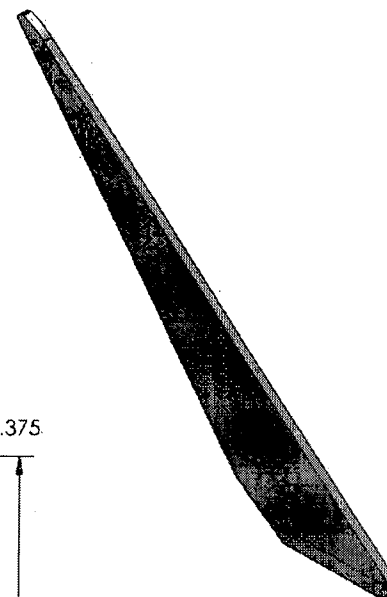
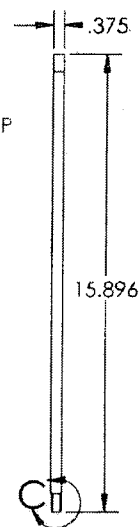
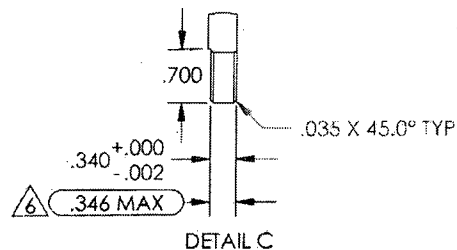
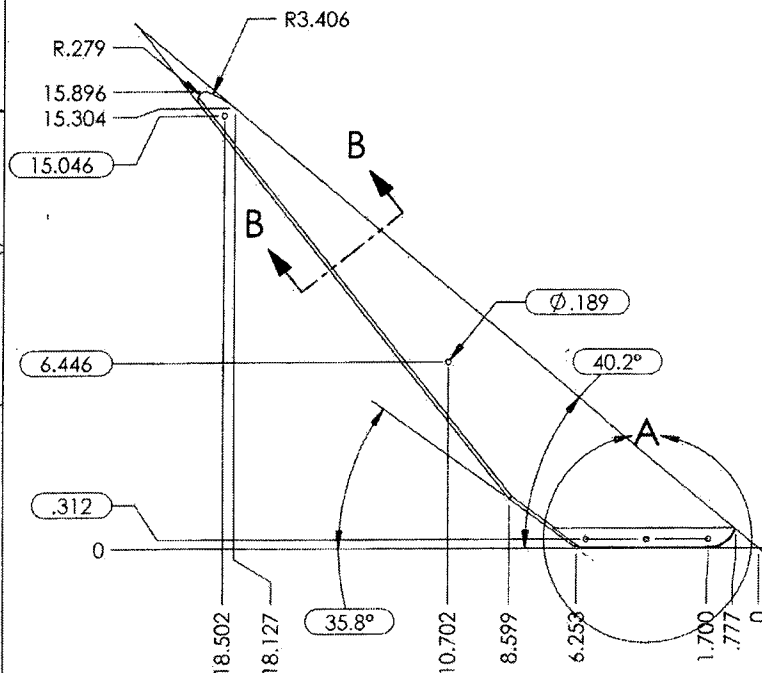
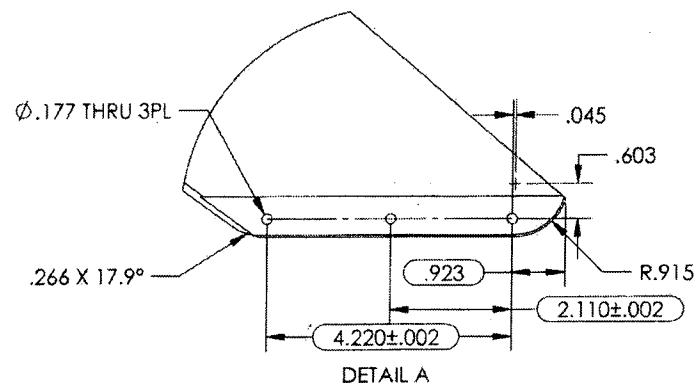
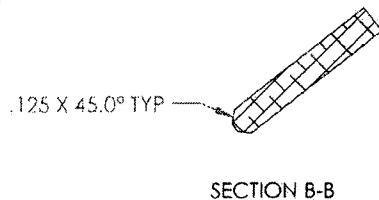
6			12	601.3072	RIVET	CS213-69	
2			11	647.3917	DOUBLER		
1			10	647.3916	DEFLECTOR, UPPER HALF	△	△
1			9	647.3915	DEFLECTOR, LOWER HALF	△	△
	1		8	647.3914	BREAKAWAY TIP LONG	△	△△
		1	7	647.3913	BREAKAWAY TIP MEDIUM	△	△△
	1	1	6	647.3912	LOWER DEFLECTOR	△	△△
			5	647.3911	212 UPPER DEFLECTOR	△	△△
			4	647.3910	412 UPPER DEFLECTOR	△	△△
A/R	A/R	A/R	3	601.2045	RTV, LOCTITE 598		△
	3	2	2	601.3074	RIVET	MS20470AD 6-12	
			1		DELETED		
X				647.3903	DEFLECTOR ASSY		△
	X			647.3902	LOWER DEFLECTOR ASSY		
		X		647.3901	LOWER DEFLECTOR ASSY		
					HIGH		
					LOW		
.3903	.3902	.3901	FINI	PART #	DESCRIPTION	MATL	SPEC
PARTS LIST							
QTY				ORIGINAL DATE			
NEXT ASSY (S)				09-10-09			
647.3800				DRAWN BY: D. SCHUR			
				CHECKED BY: D. BARBER			
				DRAWING APPROVAL			
				P. BRAVO			
				DATE: 09-10-09			
				COURTESY NO.			
				UNLESS OTHERWISE SPECIFIED			
				DIMENSIONS ARE IN INCHES			
				TOLERANCES ARE			
				FRACTIONS DECIMALS			
				3 PLACES DECIMALS .XXX			
				ANGLES ± .5°			
				SCALE: NONE			
				SHEET 1 OF 12			

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

DEFLECTORS

REV. 8 07/24/12 647.3900 C

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647.3911

ORIGINAL DATE: 08-10-00		APICAL INDUSTRIES	
DRAWN BY: D. SCHUP	CHECKED BY: D. SCHUP	2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL: P. BRAY		OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACT NO.		DEFLECTORS	
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE: 1 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 3 PLACE DECIMALS ±.001 ANGLES ±.5°		SHEET: B	REV: C
CAGE CODE: 07M26		DWG. NO: 647.3900	
SCALE: NONE		SHEET 2 OF 12	

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SECTION E-E

DETAIL D

DETAIL F

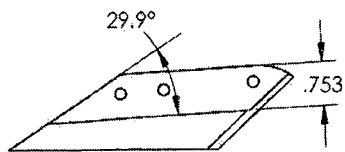
DEFLECTORS

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

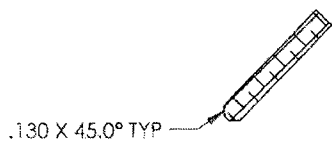
647.3900

1 SHEET 3 OF 12

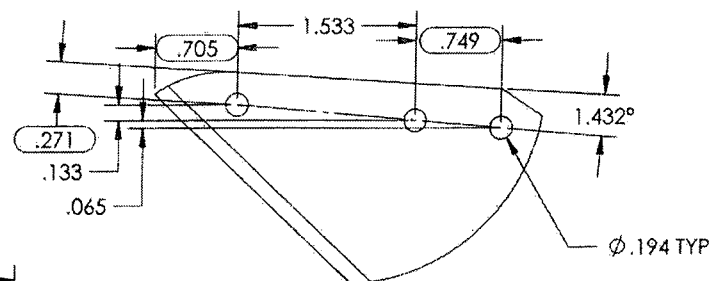
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES AND REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



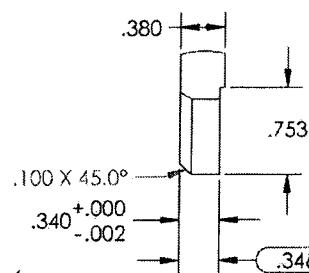
SECTION L-L



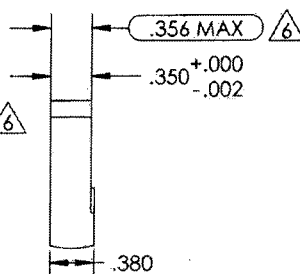
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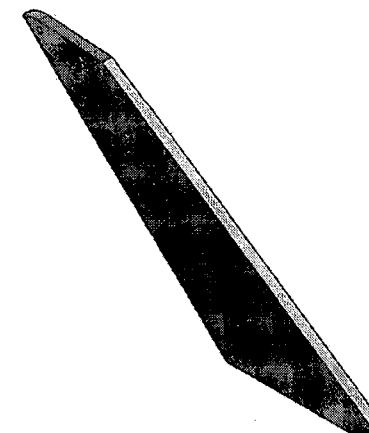
DETAIL H



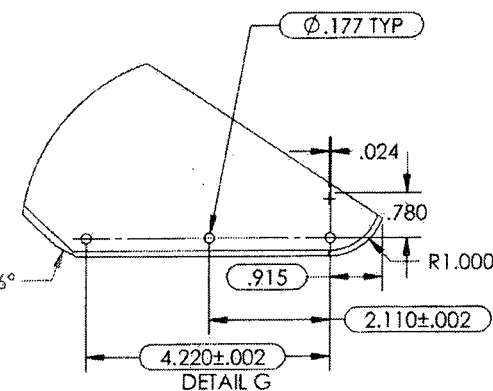
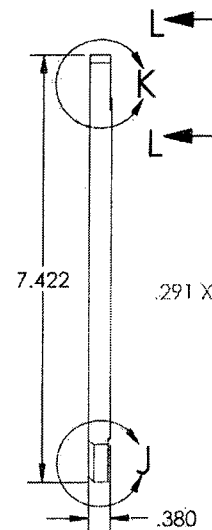
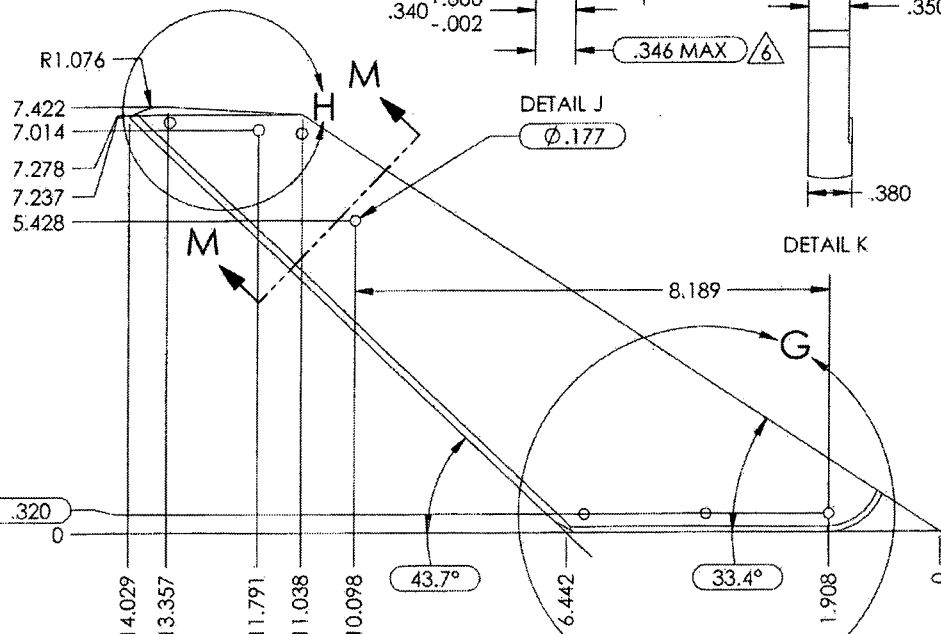
DETAIL J



DETAIL K



647.3912



ORIGINAL DATE REVISED DATE DRAWN BY CHECKED BY DESIGNED BY BY DATE CITY/STATE/ZIP		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DEFLECTORS		647.3900	
REV. C	DATE 07/14/26	DWG. NO. 647.3900	REV. C
SCALE NONE		SHEET 4 OF 12	

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SECTION N-N

.180 X 45.0° TYP

SECTION AD-AD

647.3913

DEFLECTORS

APICAL INDUSTRIES

2408 TEMPLE HEIGHTS DR.

OCEANSIDE, CA. 92056-3512 (760) 724-5300

DATE: 07-10-97

DRAWN BY: [blank]

CHECKED BY: [blank]

DESIGNED BY: [blank]

APPROVED BY: [blank]

SCALE: NONE

SHEET 5 OF 12

Key dimensions and features include:

- Section N-N: .180 X 45.0° TYP
- Section AD-AD: 3.376, .130, R1.675, .917, 1.504, 3.135, .417, 4.483, 3.696
- Assembly View: R.269, R3.534, 4.483, 3.696, 4.19°, 31.4°, R.264, 0, 1.780, 3.284, 3.414, 4.029, 7.036, 7.749, 8.007, 6.618, 0, .506, .337, 1.196, .189 THRU 2PL, .194 THRU 2PL, .480, .560, .362 +.002 / -.000, .910, .356 MIN, 6

SWE	CAGE CODE	(SWO. NO.)	REV.
B	07M26	647.3900	C
SCALE NONE		SHEET 3 OF 12	

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SECTION T-T

.175 X 45.0° TYP

SECTION AB-AB

647.3914

8.618

AB

AB

DEFLECTORS

APICAL INDUSTRIES

2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

SCALE: NONE

SHEET 6 OF 12

ORIGINAL DATE: 04-03-98
DRAWN BY: J. H. H. / J. H. H.
CHECKED BY: J. H. H. / J. H. H.
DESIGNED BY: J. H. H. / J. H. H.
ENGINEER: J. H. H. / J. H. H.
CONTRACT NO.: 647.3900

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.005
ANGLES ±.2°

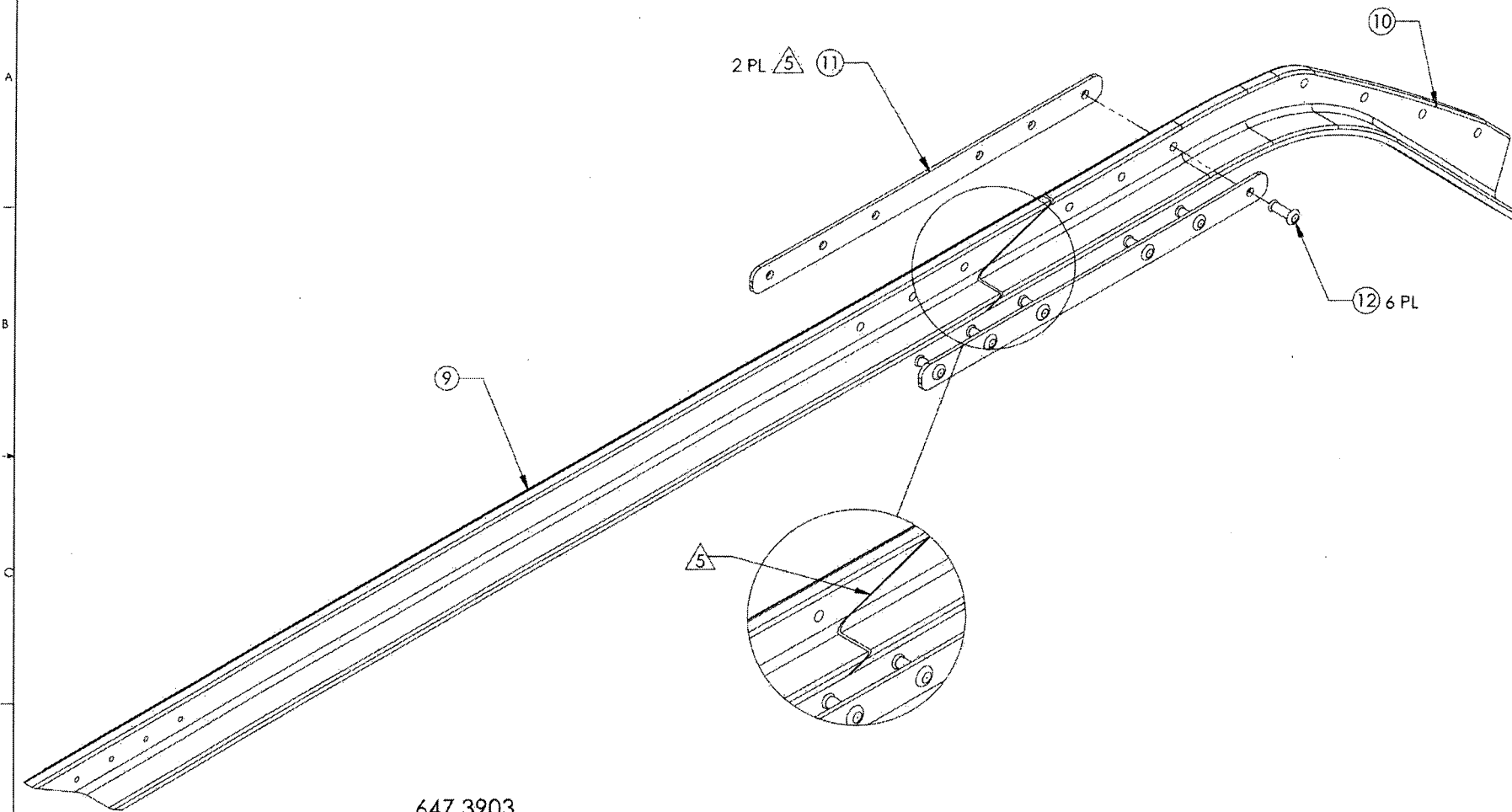
SEE: 04-03-98
B 07/14/98
DWG. NO.: 647.3900
REV. C

The drawing includes several views of a deflector assembly. The plan view shows a sloped deflector with a horizontal base. Key dimensions include a top width of 8.611, a base width of 12.148, and a vertical height of 10.597. It features two hole patterns: one with a diameter of 0.189 through two plates and another with a diameter of 0.194 through three plates. The deflector has a 42.83° angle at the base and a 37.1° angle at the top. Section T-T shows a cross-section of the deflector with a thickness of 0.175 and a 45.0° angle. Section AB-AB shows a cross-section of the deflector with a width of 3.072 and a height of 0.740. The elevation view shows the deflector's profile with a total height of 8.618 and a base width of 12.148. It includes a 0.050 typical radius and a 0.255 radius at the base. The drawing also includes a title block with the company name, address, phone number, and drawing information.

SER B	CAGE CODE 07M16	DWG. NO. 647.3900	REV. C
SCALE NONE		SHEET 6 OF 12	

1 2 3 4 5 6 7 8

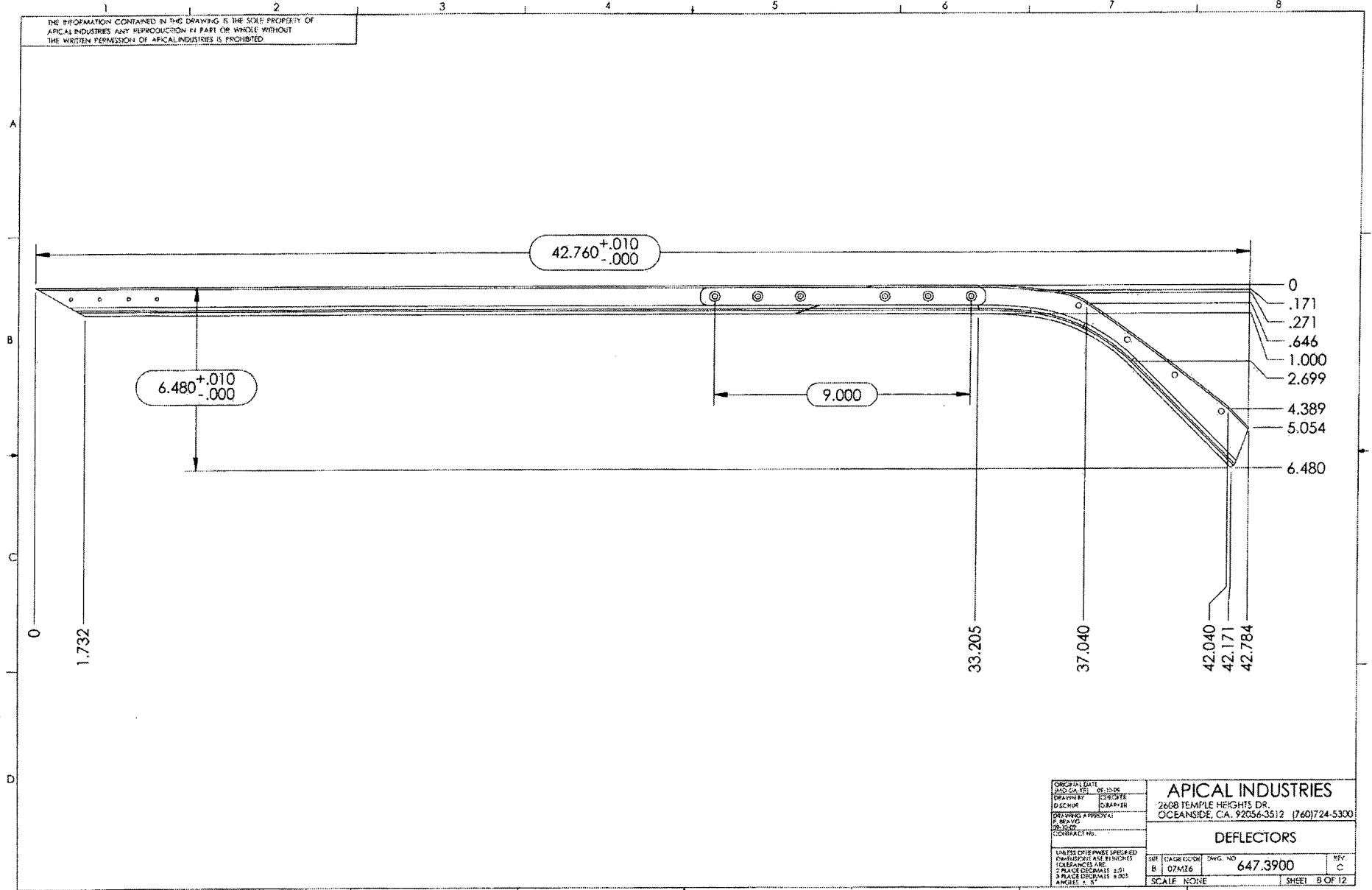
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES AND REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



647.3903

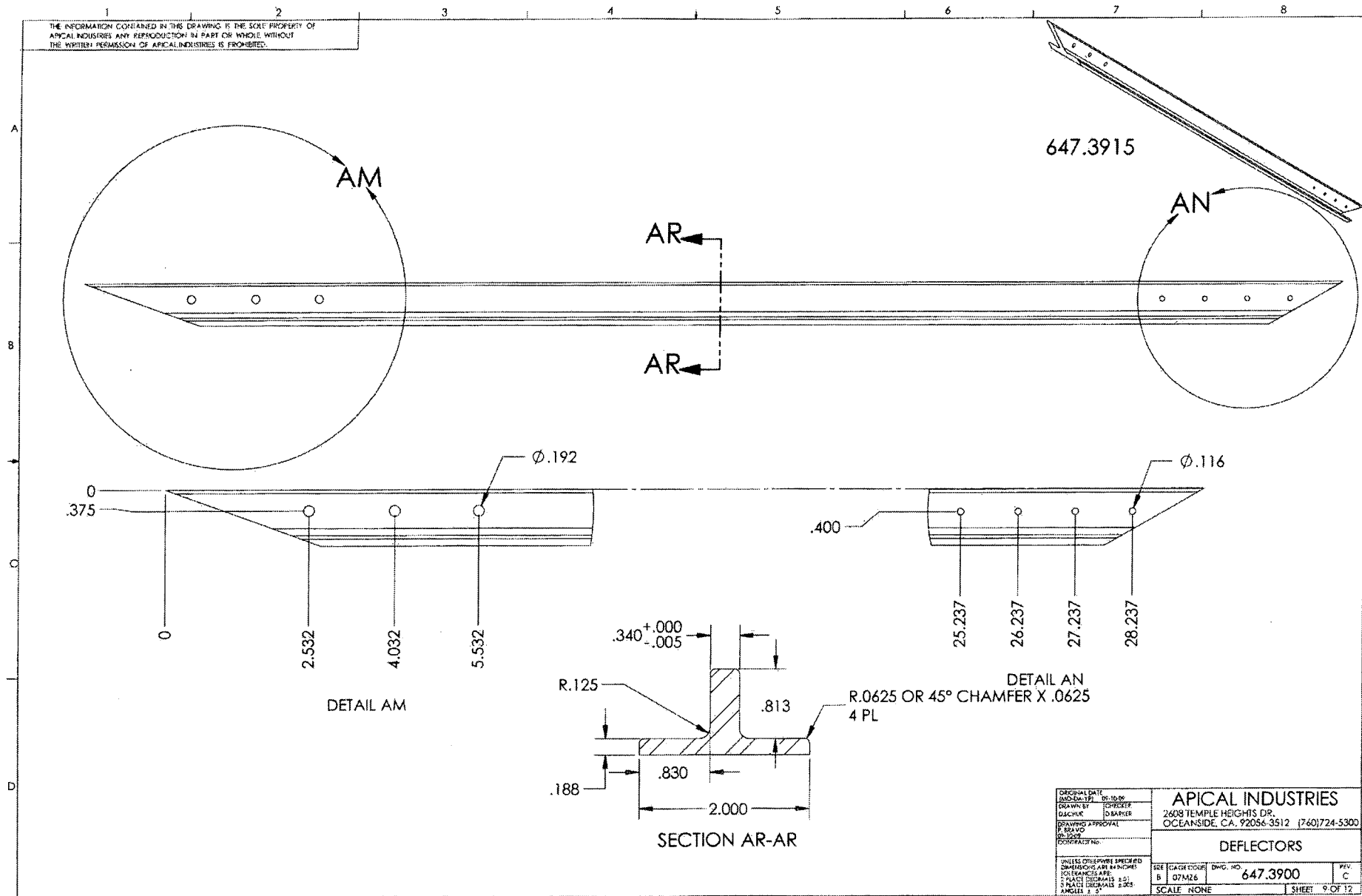
ORIGINAL DATE 05-10-00		APICAL INDUSTRIES	
DESIGNED BY D. SCHNEIDER	CHECKED BY D. SCHNEIDER	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. MALVO		DEFLECTORS	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SEE CAGE CODE B D7ME6	DWG. NO. 647.3900
		SCALE NONE	REV. C
		SHEET 7 OF 12	

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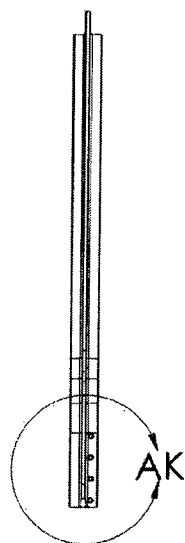
ORIGINAL DATE 09-10-06 DRAWN BY C. B. W. J. E. CHECKED BY C. B. W. J. E. DRAWING APPROVAL P. B. W. J. E. CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNITS: DIMENSIONS IN INCHES DIMENSIONS ARE IN INCHES DECIMALS ARE 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES: ± .5°		DEFLECTORS SUB: 07N216 DWG. NO. 647.3900 REV. C SCALE: NONE SHEET 8 OF 12	

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

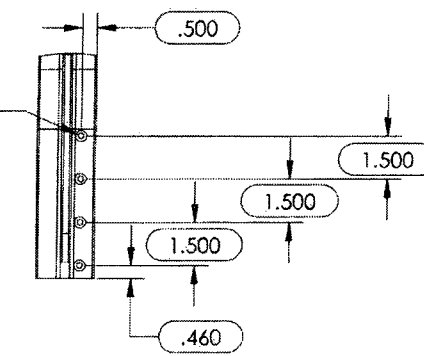


ORIGINAL DATE 06-10-00		APICAL INDUSTRIES	
DESIGNED BY GASCH	DESIGNED BY GASCH	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL BY GASCH	DRAWING APPROVAL BY GASCH	DEFLECTORS	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ARE 16THS DECIMALS ARE 10THS ANGLES ARE IN DEGREES	SIZE B	DWG. NO. 647.3900	REV. C
SCALE: NONE		SHEET 9 OF 12	

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF
APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



4X $\phi .196 \pm .010$ THRU ALL
 $\checkmark \phi .385 \pm .020 \times 100^\circ \pm 1.000^\circ$



DETAIL AK

647.3915

ORIGINAL DATE
DESIGNED BY
DRAWN BY
CHECKED BY
DATE
BY
DATE
BY
DATE

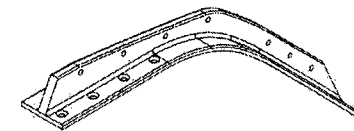
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
FRACTIONS ARE TO BE IN
DECIMALS
ANGLES ARE IN DEGREES

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760) 724-5300

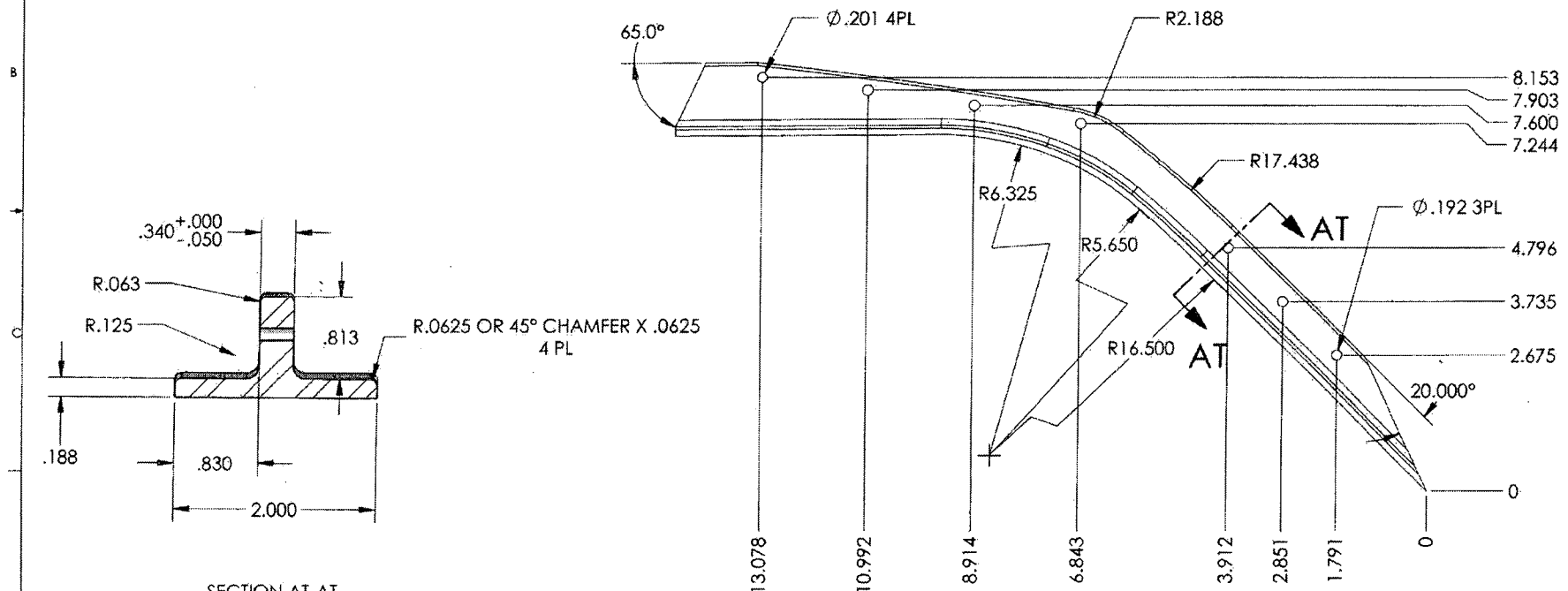
DEFLECTORS

SHEET	CAGE CODE	DWG. NO.	REV.
B	07MZ6	647.3900	C
SCALE NONE		SHEET 10 OF 12	

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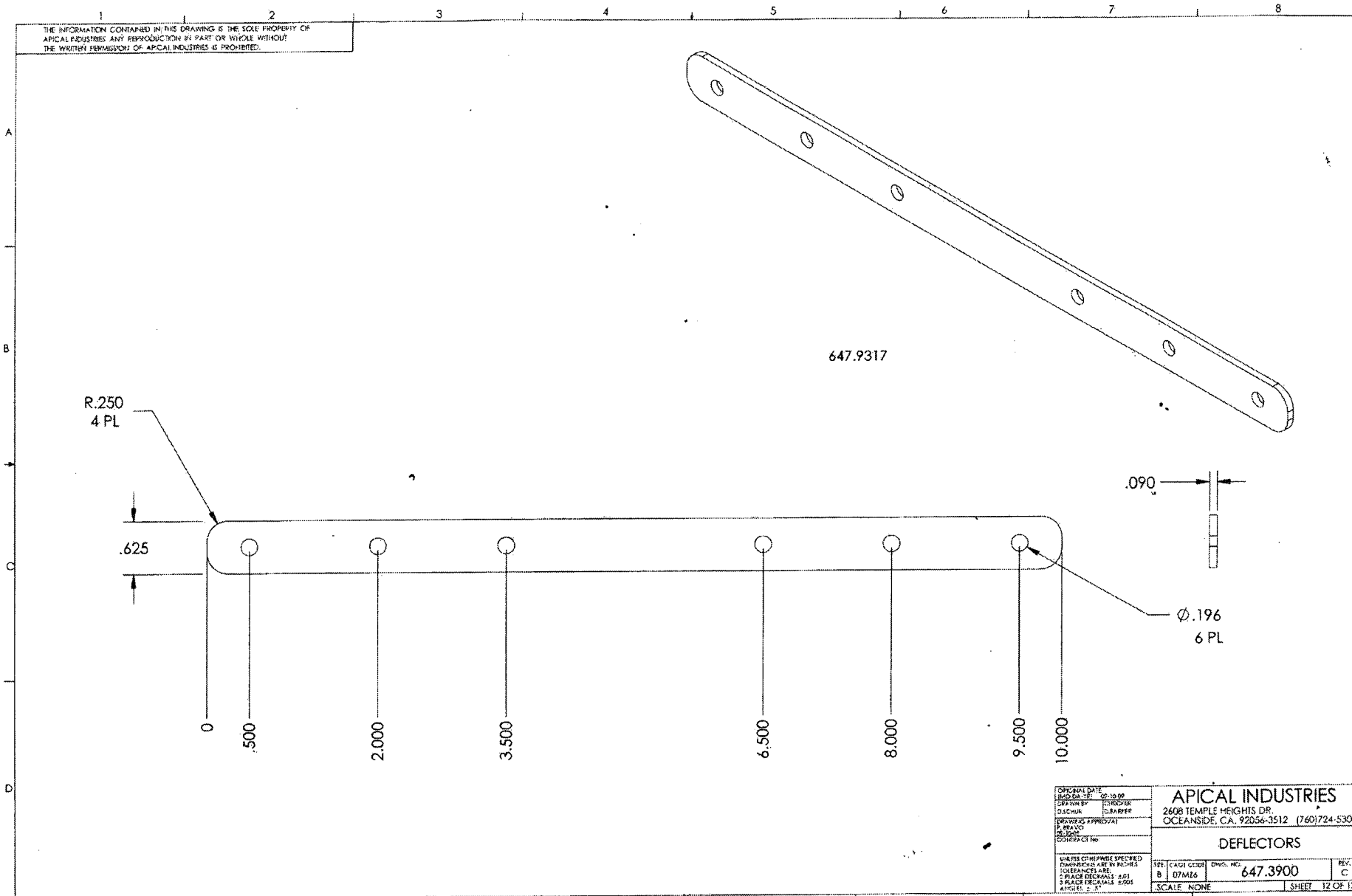
647.3916



SECTION AT-AT

OPERATIONAL DATA DATE: 01/01/00 DRAWN BY: J. B. BAKER CHECKED BY: J. B. BAKER DESIGNED BY: J. B. BAKER DRAWING APPROVAL: J. B. BAKER CONTRACT NO.:		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES 1/16" FRACTIONS 3/16" FRACTIONS 1/8" FRACTIONS ANGLES 1/2°		SHEET CODE: 07A026 DRAWING NO.: 647.3900 SCALE: NONE	REV. C SHEET 11 OF 12

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ORIGINAL DATE
DESIGNED BY: CHROSTEK
DRAWN BY: G. BARNER
CHECKED BY: P. BARNER
DATE: 02/10/00
CONTRACT NO:

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760) 724-5300

DEFLECTORS

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
FRACTIONS DECIMALS .001
ANGLES .5°

REV.	647.3900	DATE	BY
C		07/11/06	B

SCALE: NONE SHEET 12 OF 12



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO25743

Purchase Order Date 9/11/2014

PO Print Date 9/19/2014

Page Number 3 of 5

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

6	123543	647.3911 UPPER DEFLECTOR REV. C	9/23/2014	4.00	\$24.50	\$98.00
			Yes 9/23/2014			

Line Total: \$98.00

7	123482	647.3912 LOWER DEFLECTOR REV. C	9/23/2014	8.00	\$11.45	\$91.60
			Yes 9/23/2014			

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$91.60

8	122971	646.3313 UPPER GUIDE	9/23/2014	6.00	\$13.10	\$78.60
			Yes 9/23/2014			

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$78.60

Note:

9/19/2014



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63276

Date: 23-Sep-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
16 ea	Part: 647.4110 DOUBLER HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140609 PO: PO25743	Rev: N/C	Line:
18 ea	Part: 647.4110 DOUBLER HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140610 PO: PO25743	Rev: N/C	Line:
10 ea AL	Part: 646.9812 CUTTER DEFLECTOR HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140611 PO: PO25743	Rev: A	Line:
6 ea	Part: 646.9811 UPPER DEFLECTOR HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140612 PO: PO25743	Rev: A	Line:
4 ea	Part: 647.3911 UPPER DEFLECTOR HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N	Rev: C	



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63276

Date: 23-Sep-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To


DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
	HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2		
	PRIME AS PER MIL-P-23377J TYPE I CLASS N		
	PRIMER IS SUPPLY BY THE CUSTOMER		
	Job: 20140622	PO: PO25743	Line:
<p align="center">Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p align="center">ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE <u>23/9/14</u></p> <p>CERTIFIED SIGNATURE : <u></u></p> <p>RECEIVER SIGNATURE : _____</p>			